



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-796-151
Job Sheet 170342-A



Part No: D119-796-151

Job Qty: 1 ea

Part Name: Fwd Crosstube Installation With Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/15/18

Job Tracking No:

Due Date: 1/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D119-796-151 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:C 14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:D 15-02-11 AS PER REV D JLM VERIFIED BY:DD IPP REV:E 17.12.11 REMOVE PICK KIT DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/25/18	0.00	0.00	Start Up Crosstubes-1		AS APR 23 2018
130	Crosstubes	1 pcs		1/26/18	0.00	0.49	Crosstubes-1		AS APR 23 2018
140	QC	1 pcs		1/26/18	0.00	0.00	QC5		38
145	DC	1 pcs		1/26/18	0.00	0.00	DC		AS APR 23 2018
150	Packaging	1 pcs		1/26/18	0.00	0.00	Packaging3-1	LG050	AS APR 23 2018
160	QC21-FG	1 Ea		1/26/18	0.00	0.00	QC21		

Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-151 ***Torque all clamps to 50 IN-LBS max.***
Descriptions: 140 - ***RE-CHECK TORCQUE ON CLAMP AS PER DWG ***

145 - Photocopy bluefile and create labels as per PPP D119-796-151 chg 004

150 - Identify and pack for shipping as per PPP D119-796-151

DAS APR 23 2018
21
9-80

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation 171230	D119-796-141 5048069	①	6	0	0
	D5123-3 5006028	④	358	0	0
	D5149-041 5054204	②	1	0	0
	MS21920-22 5013763	④	130	0	0

Part Specifications

Specifications could not be found.

Plex 1/15/18 11:13 AM Dart.lajeunesse.marie



Container No: S063816



Part: D119-796-151

Job No: 170342-A

Serial No/Batch: S063816

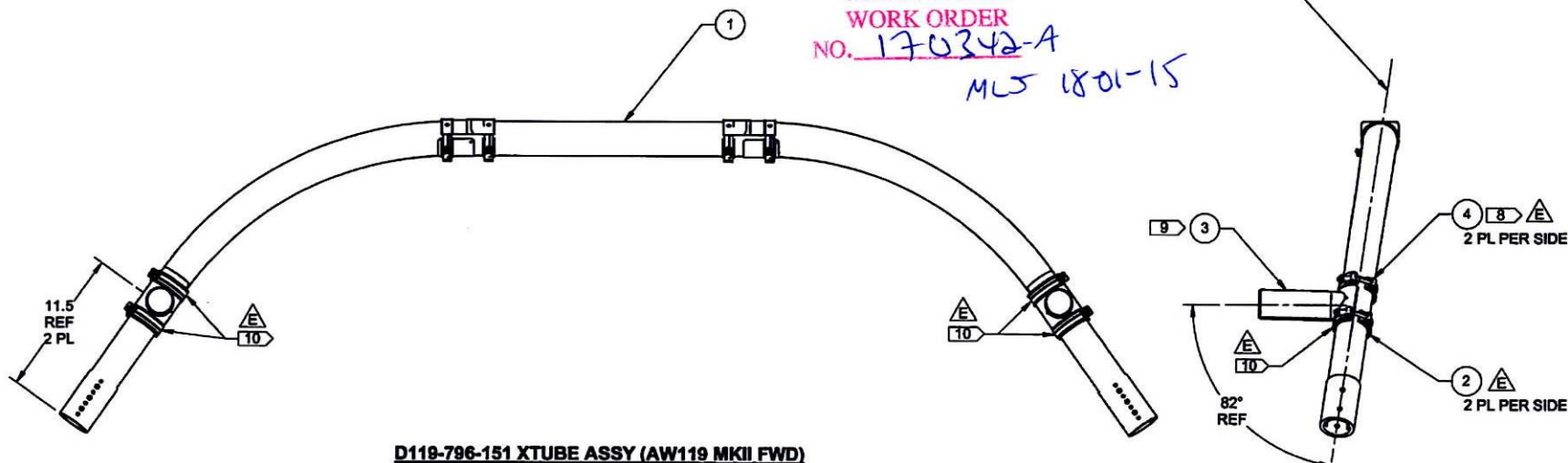
Revision: E/F

Inspector:

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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170342-A
MLJ 1801-15



D119-796-151 XTUBE ASSY (AW119 MKII FWD)

NOTES:

- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
 - 7) WEIGHT: 20.01 lbs
 - 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
 - 9) LOCATE STEP USING POST FITTING ON CROSSTUBE
 - 10) POSITION MS21920 CLAMPS SECURING THE STEPS AS SHOWN.
- THE THREADED PORTION OF THE CLAMP MUST FACE THE SAME DIRECTION AS THE STEP

E	MODIFY CLAMP ORIENTATION, ADD NOTE 10 (PAR16-527) UPDATE WEIGHT DUE TO -141 CHANGE	ML	17.02.10
D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION, MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, AN4C6A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D119-796-151 TITLE XTUBE ASSY (AW119 MKII FWD) COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	ML		
CHECKED	AJS		
MFG. APPR.	DP		
APPROVED	WM		
DE APPR.	DS	REV. E SHEET 1 OF 1 SCALE NTS	
DATE	17.02.10		

RELEASED
2017-05-04
ECN 17-538

APPROVED

PAGE 1 OF 1

Description: CROSSTUBE INSTALLATION, FWD STD, WITH PEG STEPS

H:\Forms\Engineer\Approved Eng Online\CHGREC revB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					